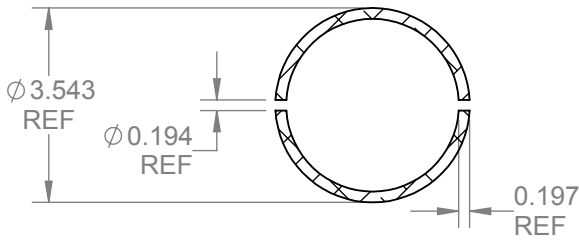


D135-1027-253 MID HEIGHT AFT CROSSTUBE
BENDING AND DRILLING DETAIL



- NOTES:**
1) MATERIAL: MANUFACTURED FROM D6027-115
STRAIGHT LENGTH = 114.08±0.06 (BEFORE BENDING / TRIMMING)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 20.57 lbs
8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25
9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE
10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

PRELIMINARY ISSUE

17-01-24 ML

WORK IN PROGRESS

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MFG. APPR.		D135-1027-253	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		MID HEIGHT AFT XTUBE	NTS
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